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D350-591-312
Job Sheet 167784



Part No: D350-591-312

Job Qty: 5 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Ship Via:

~~NOT AIRBUS~~ CHG 00001

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Large Fab2		SL 17/4/12
110	Large Fab	5 pcs	11/23/17	11/23/17	0.00	5.00	Large Fab 2		SL 17/5/12
120	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC9		PD 17-12-08
130	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC5		PD 17-12-06
140	HandFinish	5 pcs	11/23/17	11/23/17	0.00	0.94	HandFinish1		2017-12-06 JSL
150	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC7		PD 17-12-12
180	Large Fab	5 pcs	11/23/17	11/23/17	0.00	5.00	Large Fab 2		SL 17/12/13
190	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC10		38 38 38
200	QC	5 pcs	11/23/17	11/23/17	0.00	0.00	QC5		38 38 38
210	HandFinish	5 pcs	11/23/17	11/23/17	0.00	0.94	HandFinish1		BEB 17/12/14
220	Powdercoat	5 pcs	11/23/17	11/23/17	0.00	1.49	Powdercoat1		BR 17-12-15
230	HandFinish	5 pcs	11/24/17	11/24/17	0.00	0.94	HandFinish3		BEB 17-12-18
240	QC	5 pcs	11/24/17	11/24/17	0.00	0.00	QC3		38
250	Packaging	5 pcs	11/24/17	11/24/17	0.00	0.00	Packaging1		17-12-18
260	QC	5 pcs	11/24/17	11/24/17	0.00	0.00	QC4		17-12-18
265	DC	5 pcs	11/24/17	11/24/17	0.00	0.00	DC		17-12-18
270	Packaging	5 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		17-12-18
280	QC21-FG	5 Ea	11/24/17	11/24/17	0.00	0.00	QC21		17-12-18

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:00 OVEN TEMPERATURE: 300 FINISH TIME: 1:30

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

wing walk. A138423

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	✓ D3067-1 5012005	5	38	0	0
	✓ D3219-1 F160384-1	10	57	0	0
	✓ D3272-1 5008818	5	3	0	0
180-Large Fab	✓ D3065-041 5016987	5	11	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

250-Packaging

✓ D3066-1 5012395	10	28	0	0
✓ D3067-1 5012005	5	38	0	0
5016823 ✓ MS20600-AD4W4	80	686	0	0
AN3-35A 5027222	10	22	0	0
AN4-13A 5027221	40	477	0	0
AN5-36A 5027218	10	102	0	0
D2230-3 5027204	20	111	0	0
D2618 5027200	10	139	0	0
102856-40-22 ✓ D2856-400 5027195	6	275	0	0
D3235-1 5027194	10	13	0	0
D3278-041 5027188	5	27	0	0
✓ DSL9440-011 5027184	5	0	0	0
MS21042L3 5027192	10	1,433	0	0
MS21042L4 5027176	40	1,670	0	0
MS21042L5 5027174	10	427	0	0
NAS1149D0363J 5027173	20	598	0	0
NAS1149D0463J 5027171	80	1,482	0	0
NAS1149D0563J 5026643	20	1,394	0	0
5027272				

Part Specifications

Specifications could not be found.

Plex 11/6/17 3:52 PM dart.poulin.mario

DART
AEROSPACE
S016750

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Heli - Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 312

Revision:

Operation: Large Fab

Change No:

Mfg Date: 12/04/17

Job No: 167784

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]